

Date: Friday, 9/21/2007 1:18:27 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BUSHING	
Job Number	34811				
Estimate Number	10175				
P.O. Number	N/A		Part Number	D2570	
This Issue	9/21/2007	S.O. No.	N/A	Drawing Number	D2570 REV B
Prsht Rev.	NC		Project Number	N/A	
First Issue	9/21/2007	Type	MACHINED PARTS	Drawing Revision	B
Previous Run	33559		Material	N/A	
Written By			Due Date	10/20/2007	
Checked & Approved By	<u>JL 07.09.24</u>		Qty:	500	Um: Each
Comment	Est E 02.08.29 Re-format; Removed finishing; Material change K J est F 07.07.06 rev B dwg EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M303R0750	303 Round Bar .75"
		Comment: Qty.: 0.0810 f(s)/Unit Total : 40.4775 f(s) <i>M105801-x 32.9'</i> Material: Ø0.750 AISI 303 SS Rod (M303R0.750) Batch <i>M104973-x60 DTP 07/10/01 JL 07/10/02-03</i> <i>51.3'</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA198 Deburr and tumble <i>DTP 07/10/01 JL 07/10/02-03</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>DTP 07/10/01 JL 07/10/02-03 505</i>
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>JL 07/10/03</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>EJ 07/10/03 505</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/10/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:18:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 34811

Part Number: D2570

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(SCS)

Comment: FINAL INSPECTION/W/O RELEASE

10/21/07

Job Completion



10/21/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34811
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	DJP
Date:	07/10/01

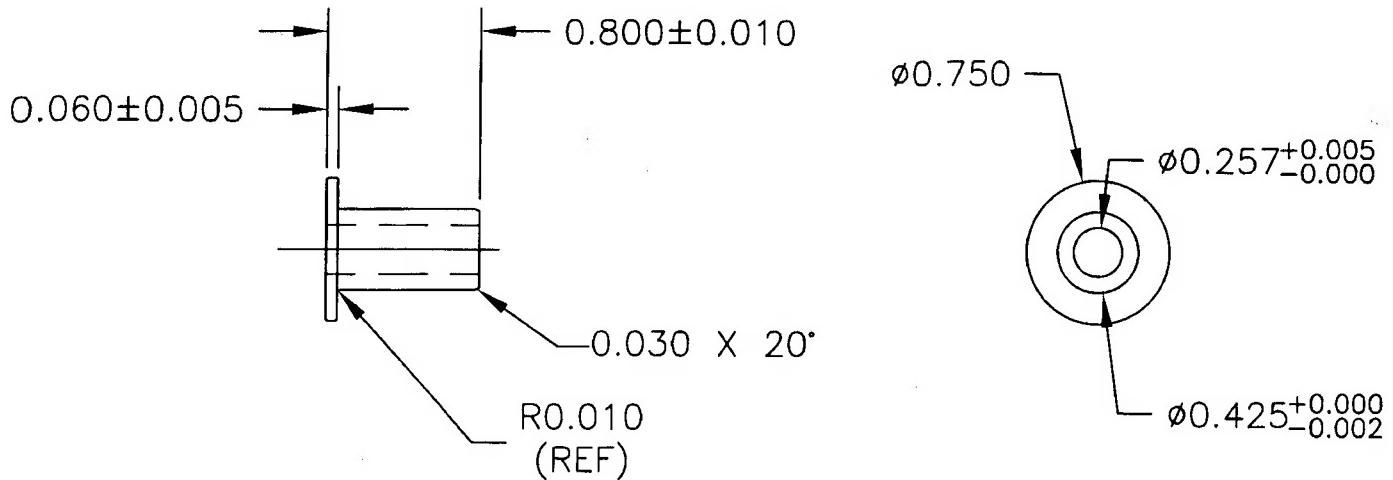
Audited by:	
Date:	07.10.01 <u>07.10.01</u>

Prototype Approval:	N/A
Date:	/

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue	KJ/RF	✓
B	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
C	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	✓ ✓

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2570	REV. B SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	07.04.17	UPDATE NOTES	

RELEASED
07.06.28 #**D2570 BUSHING****D2570 BUSHING**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

SH-100 Y
RE-100 C
ENG-100 M
UNCONT'D
SUBJECT TO CHANGE
W/11
NO. 34811

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.